

Work Order ID 134823

134823

Page 1

July 21, 2015 1:27:13 PM

Item ID: D4173-6 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod Radalt Mounting Plate, RH
 Start Date: 7/21/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 1.00 *1* Customer:
 Reference: / MLJ

Approvals: Process Plan: S/day 15/7/21 Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4173	A								

100 0.00
 100
 Waterjet Memo 0.00 (2) 02/15/07/24
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: A
 Prog Rev: 1A
 2-Deburr if necessary

110 0.00
 110
 QC Memo 0.00 (2) 02/15/07/24
 Quality Control QC2- Inspect parts off machine FAI/FAIB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 134823

134823

Page 2

July 21, 2015 1:27:13 PM

Item ID: D4173-6 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pod Radalt Mounting Plate, RH
 Start Date: 7/21/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/11/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(2)			DAS 38 9-89 JUL 27 2015
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00			DAS 30 9-89	2			JUL 27 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(2)			DAS 38 9-89 JUL 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

134823

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location: ST 571

0.00

150

Packaging

Memo

0.00

Packaging

27
9-89
JUL 28 2015

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

15/7/28 

SH 20150728

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

July 21, 2015 1:27:26 PM

Page 1

Work Order ID: 134823

134823

Parent Item: D4173-6

D4173-6

Parent Item Name: Pod Radalt Mounting Plate, RH

Start Date: 7/21/2015

Required Date: 8/11/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	416.5363	0.0814	0.085684			

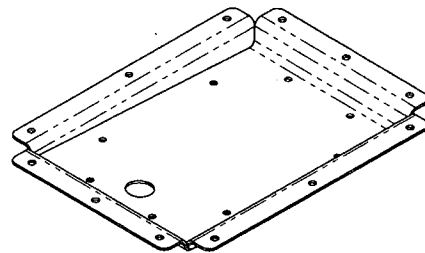
M6061T6S 063

6061-T6 .063 Sheet

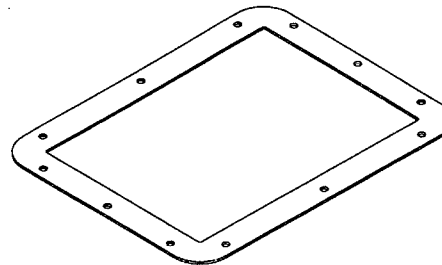
**

06/15/07/24

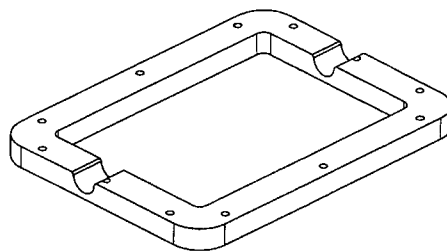
Location	Loc Qty	Loc Code
MAT	48.75	
M131653	48.75	
MAT021	367.7863	
M128941	7.932	
M129845	29.2743	
M130096	18.2	
M131322	69.83	
M131383	40.5	
M132358	202.05	



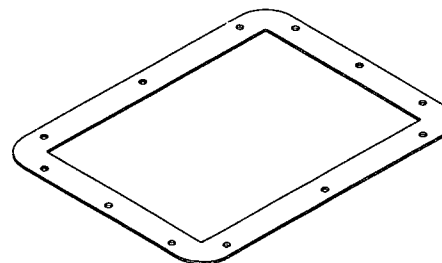
D4173-041 POD RADALT MOUNTING PLATE ASSY



D4173-3 POD RADALT DOUBLER



D4173-7 RADALT SHIM



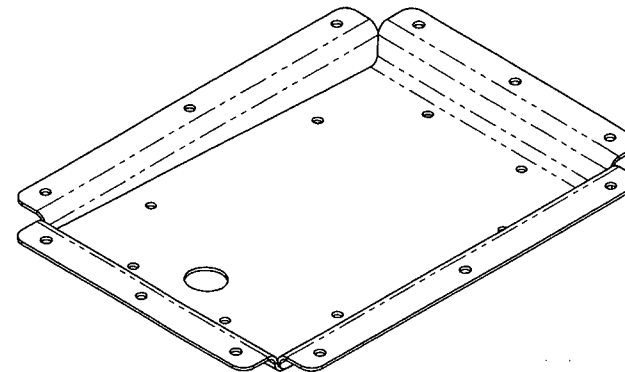
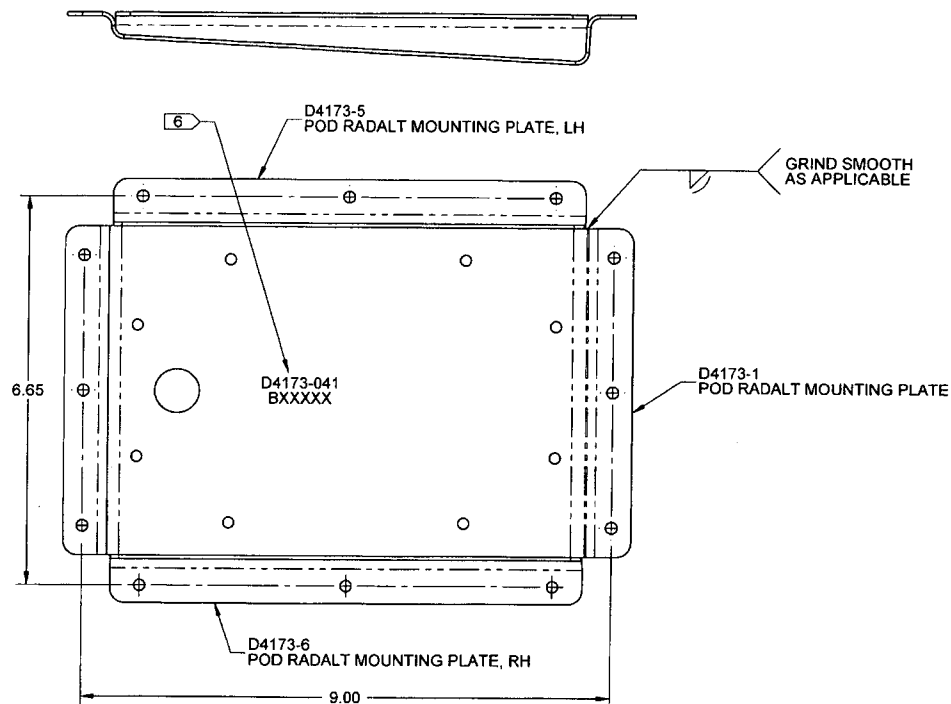
D4173-9 POD RADALT SEAL

134823
15/7/21
3H

RELEASED
2010-09-29
JH

A	NEW ISSUE	MB	10.09.01
REV.		BY	DATE
DESIGN		DESCRIPTION	
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4173	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4173-041	POD RADALT MOUNTING PLATE ASSY
1	1	D4173-1	POD RADALT MOUNTING PLATE
2	1	D4173-5	POD RADALT MOUNTING PLATE, LH
3	1	D4173-6	POD RADALT MOUNTING PLATE, RH



D4173-041 POD RADALT MOUNTING PLATE ASSY

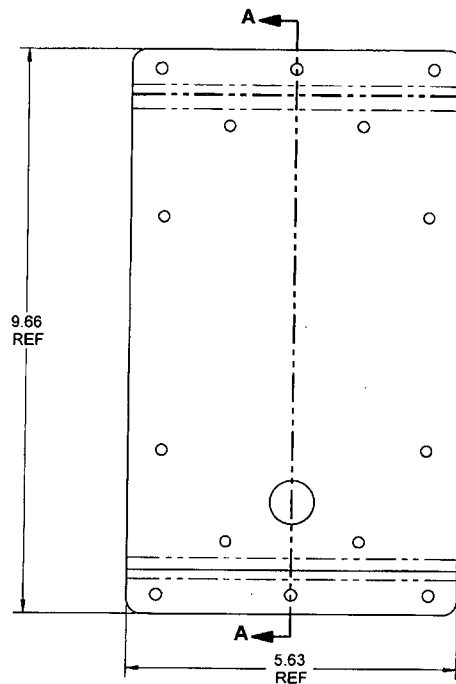
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) WELDING: PER DART QSI 004

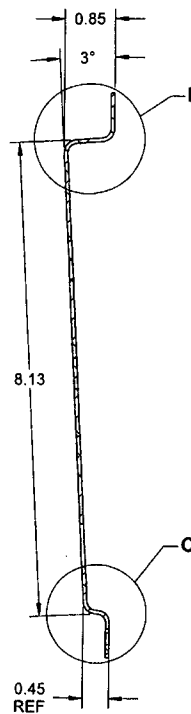
RELEASED
2010-08-29
ND

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4173	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 8
APPROVED		POD RADALT MOUNTING PLATE ASSY NTS	SCALE
DE APPR.			
DATE	10.09.01		

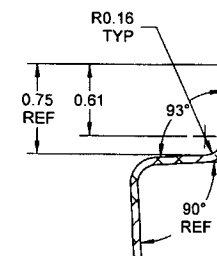
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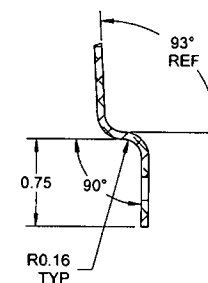
D4173-1 POD RADALT MOUNTING PLATE



SECTION A-A



DETAIL B
SCALE 2X

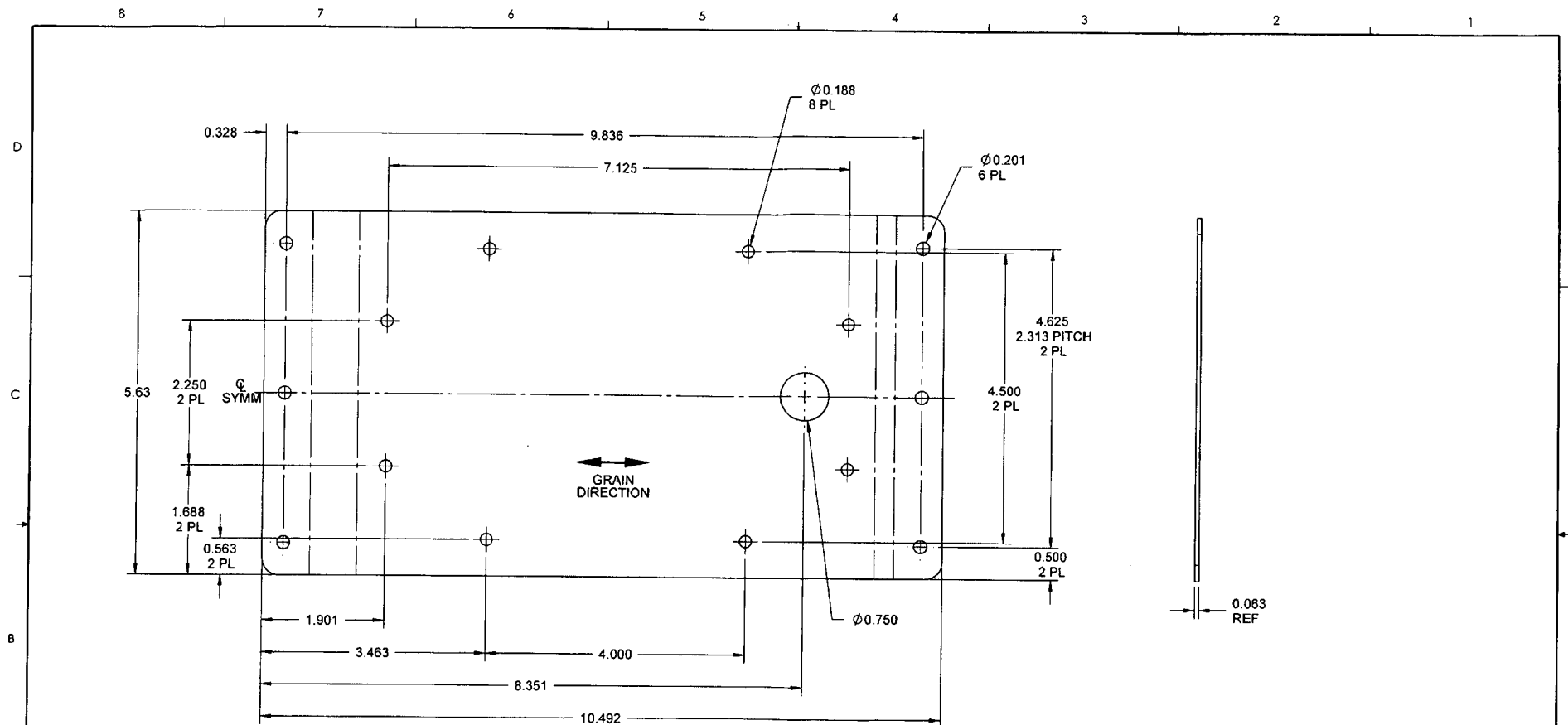


DETAIL C
SCALE 2X

- NOTES:**
- 1) MATERIAL: MAKE FROM D4173-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.50 lbs

RELEASED
2010-09-29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4173	REV. A
MFG. APPR.		SHEET 3 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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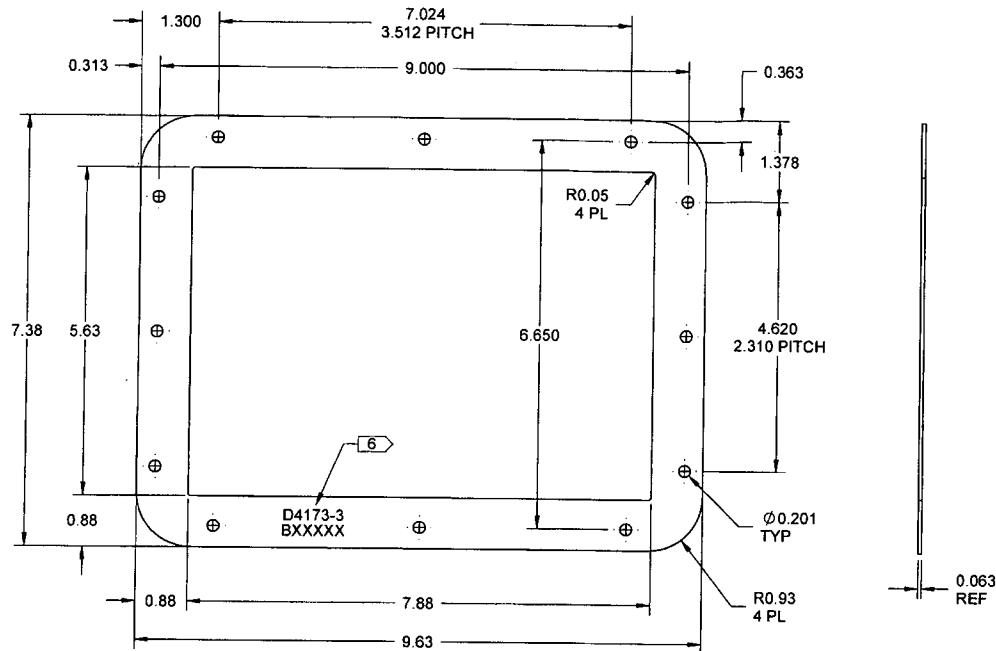
D4173-1F POD RADALT MOUNTING PLATE FLAT PATTERN

RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.36 lbs

DESIGN	18	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	18			
CHECKED	18		DRAWING NO.	REV. A
MFG. APPR.	18		D4173	SHEET 4 OF 8
APPROVED	18		TITLE	SCALE
DE APPR.	18		POD RADALT MOUNTING PLATE ASSY NTS	
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD		
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D4173-3 POD RADALT DOUBLER

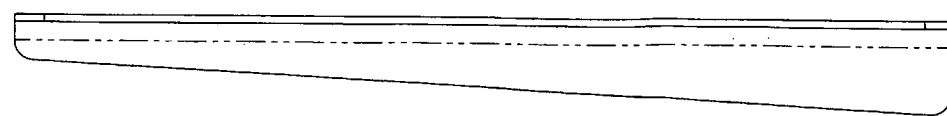
RELEASED
2010-09-29

NOTES:

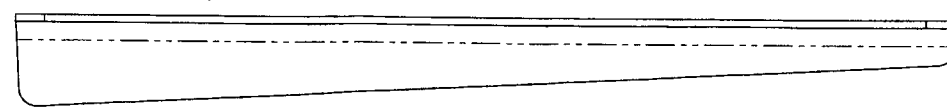
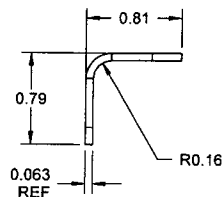
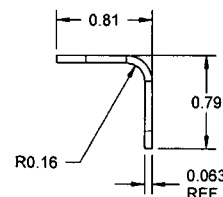
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4173	REV. A
MFG. APPR.		SHEET 5 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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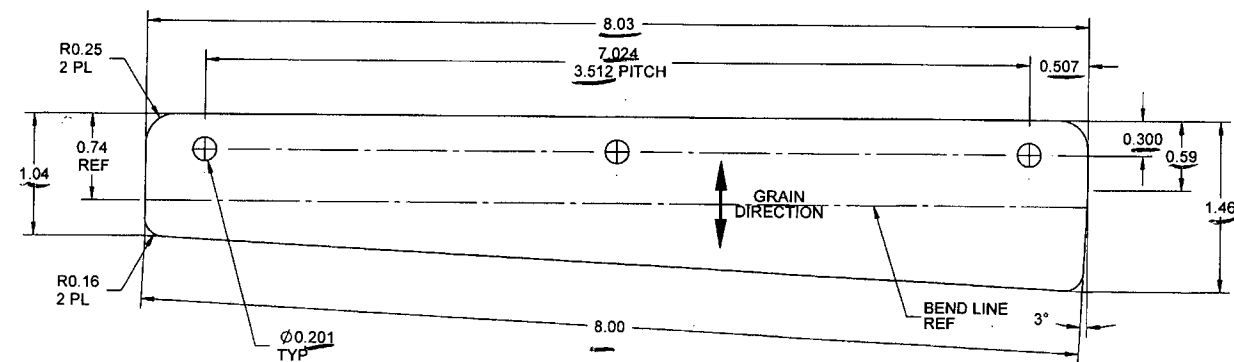
8 7 6 5 4 3 2 1



D4173-5 POD RADALT MOUNTING PLATE, LH
MAKE FROM D4173-5F



D4173-6 POD RADALT MOUNTING PLATE, RH
MAKE FROM D4173-5F



D4173-5F POD RADALT MOUNTING PLATE FLAT PATTERN

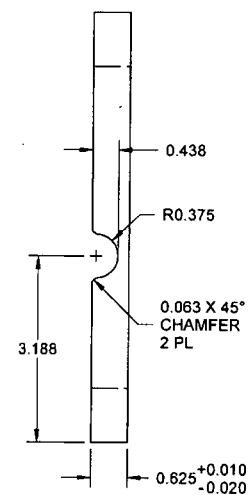
RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M8061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4173	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY	NTS
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



RELEASED
2010-09-29
mp

1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMWB

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

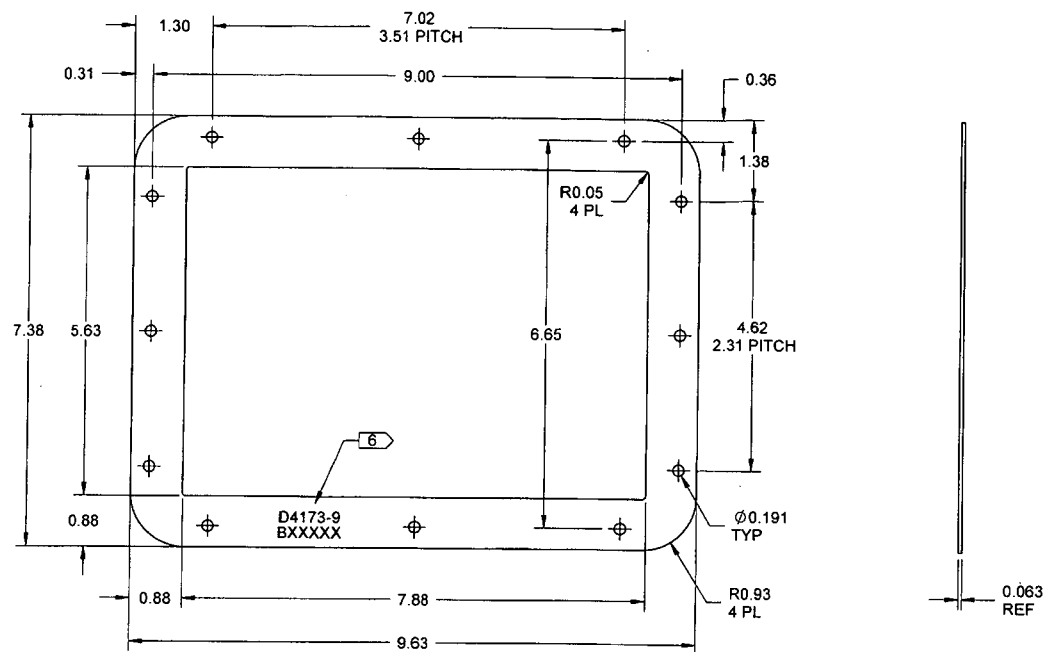
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: PER QSI 044 6.4

7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4173 TITLE POD RADALT MOUNTING PLATE ASSY COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED FOR YOUR INFORMATION. NO WARRANTIES OR REPRESENTATIONS ARE MADE BY DART AEROSPACE LTD THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITING AUTHORIZATION FROM DART AEROSPACE LTD.	REV. A
DRAWN			SHEET 7 OF 8
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	10.09.01		



D4173-9 POD RADALT SEAL

RELEASED
2010-09-29

NOTES:

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK
REF. DART SPEC. M-NEO60-S.0.63
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4173	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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FIRST ARTICLE INSPECTION CHECKLIST

Row	Date	Change	Reviewed
E	10.04.14		

10.04.15